

WHAT IS CLAIMED IS:

5 1. An improved breast form comprising:
a flexible chamber formed from a thermoplastic film material;
a volume of silicone gel composition sealably disposed within the flexible chamber; and
a fabric material disposed over and permanently joined to the thermoplastic film material.

10 2. The breast form as recited in claim 1 wherein the flexible chamber is formed from
two sheets of the thermoplastic film material that are sealed together around a perimeter edge of
the breast form.

15 3. The breast form as recited in claim 1 wherein the fabric material is formed from
a four-way stretchable fabric.

4. The breast form as recited in claim 1 wherein the silicone gel composition
comprises greater than 40 percent by volume low-density filler.

20 5. A breast form comprising a volume of silicone gel material encased within a
flexible chamber formed from a fabric laminated thermoplastic film, the fabric laminated
thermoplastic film comprising a fabric layer and a thermoplastic layer that are inseparably
adjoined together, wherein the thermoplastic layer defines an inner layer of the chamber and is
in contact with the silicone gel material, and the fabric layer defining an outer layer of the
25 chamber that forms an outer surface of the breast form.

6. The breast form as recited in claim 5 wherein the fabric layer is formed from a
four-way stretchable material.

30 7. The breast form as recited in claim 5 wherein the thermoplastic layer is formed
from a polyurethane film.

8. The breast form as recited in claim 5 wherein the flexible chamber is formed from
two sheets of the fabric laminated thermoplastic film, wherein the two sheets are heat-sealed

together along a perimeter seal of the breast form, and wherein the thermoplastic layers of the two sheets are in direct contact with each other.

9. The breast form as recited in claim 5 wherein the fabric laminated thermoplastic film is folded and positioned to create a desired shape of the breast form, wherein a portion of the thermoplastic layer is positioned over a different portion of the thermoplastic layer, and the perimeter edges of the overlapping thermoplastic layer portions are heat-sealed to form a permanent seal that prevents the silicone gel material from escaping the breast form.

10. The breast form as recited in claim 5 wherein the silicone gel material comprises a composition comprising greater than about 40 percent by volume low-density filler.

11. The breast form as recited in claim 5 wherein the silicone gel material comprises less than about 60 percent by volume organo-polysiloxane.

12. The breast form as recited in claim 5 further comprising a permanently grown pressure-sensitive adhesive adjoined to the fabric layer on an interior surface of the breast form that faces a user's breast or skin.

13. The breast form as recited in claim 12, wherein the permanently grown pressure-sensitive adhesive has an adhesion force to the fabric layer that is greater than a cohesion force to the user's breast or skin.

14. A breast form comprising a volume of silicone gel material encased between two sheets of fabric laminated thermoplastic film, wherein the two sheets are positioned on opposite sides of the volume of silicone gel material and are heat-sealed to one another along a perimeter seal of the breast form, wherein each sheet comprises a fabric layer and a thermoplastic layer that are permanently adjoined together, wherein the thermoplastic layer of each sheet is positioned adjacent the volume of silicone gel material and is adjoined to one another along the perimeter seal of the breast form, wherein the fabric layer forms an exposed surface of the breast form, and wherein the fabric layer is formed from a four-way stretchable material.

15. The breast form as recited in claim 14 wherein the thermoplastic layer is a polyurethane film.

5 16. The breast form as recited in claim 14 further comprising a permanently grown pressure-sensitive adhesive material adjoined to the fabric layer on an interior surface of the breast form that faces a user's breast or skin.

10 17. The breast form as recited in claim 16, wherein the permanently grown pressure-sensitive adhesive has an adhesion force to the fabric layer that is greater than a cohesion force to the user's breast or skin.

15 18. An improved breast form comprising:
a flexible chamber formed from a pair of polyurethane sheets that are sealed together along a perimeter edge of the chamber;
a volume of silicone gel composition sealably disposed within the flexible chamber; and
a fabric material that is disposed over and permanently joined to a surface portion of each of the polyurethane sheets and forming exterior surfaces of the breast form, wherein the fabric material is a four-way stretchable fabric.

20 19. The breast form as recited in claim 18 further comprising a permanently grown pressure-sensitive adhesive material adjoined to the fabric material on an interior surface of the breast form that faces a user's breast.

25 20. A method for forming an improved breast form having a fabric covered outer surface, the method comprising the steps of:

30 forming first and second breast form chamber members by permanently joining together sheets of thermoplastic film material with sheets of fabric material, wherein two such so-joined sheets form the first and second chamber members;

combining the first and second breast form chamber members with one another so that the sheets of thermoplastic film material are positioned opposite one another so as to form a chamber, and the sheets of fabric material form an outside surface of the breast form; and

inserting a desired volume of silicone gel material into the chamber;

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wherein during the step of combining or inserting, the sheets of thermoplastic film are sealed together along a perimeter edge of the chamber.

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Section 15-20

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